Work Orde <i>May-28-13 8:48</i>						*102	2376*						Page 1
Revision ID:	D2947 Clamp	377	B 2 9	2376		Accept	*N900	040	100)* s	etup Sta	IV	S1* S2*
Start Date: Required Date: Reference:	5/27/13 5/27/13		t Qty: 60.00 'd Qty: 60.00		60* 60*		Cust Item I Customer:	D:					
Approvals:			MLJ					ate:		R	tun Sta St	!/	IR1* IR2*
Sequence ID/ Work Center ID)	-	ration ription			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		Revision I	Nbr										
D2947		Rev A1										6	
*100		PURC	CHASING			0.00				100	0		JM30770
Waterjet FLOW CNC Waterje	et		Memo 1-Cut as pe Dwg Rev:_ Prog Rev:_ 2-Deburr if	AL		0.00							
110		QC2-	Inspect parts off r	nachine FAI/FAI	В	0.00							
110 QC			Memo			0.00				100	0		JM13-07-10

Quality Control

NCR: Ye	es / No				WORK ORDER NON-	CON	FORM	MANCE / UP	DATE	·		
			<u></u>							QA Closed:	Date:	
Work Ordei	r:				DISPOSITION				AGAINST DE	PARTMENT		
Part N	0				Rework Scrap		ı	Skid-tube Machining	Crosstube Small Fab	-1	Water Jet d. Eng. Coor.	Engineering Quality.
NCR N	o	<u>.</u>			Use-as-is Work Order Update	╛╽		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	In	nitial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling												
Operator					•	ļ						
Material							,	٠				
Setup												
Other												
Process												
Supplier												
Fraining												
Unapproved					·							
						FAULT	CATE	GORY				
Landin	g Gear				General			· ·				
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre No	ot Concei	ntric to (o/s	BOM/Route	\Box	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
. [Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorred	ct 🗀	Weld
Ī	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
Ī	Cuffs				Contamination	П	Mainte	enance		Part Moved		-
· [Heat Trea	at			Countersink	П	Mislabe	eled	,	Positioned V	Vrong	
Ī	Inspectio	n Strip in	Tube		Cut Too Short	П	Misread	d		Power Loss/	Surge	Other
-	Ripples ir				Drill Holes		Offset				L	
ţ	Torque V		Extrusion	,	Drawing		Out of 0	Calibration		•		
ľ	Turning S				Finish	Н	Out of 9	Sequence		***		
ľ	Wave/Tw				Folio	\vdash		Dimensions				

DQA:

Date:

Work Ordo <i>May-28-13 8:48</i>		102376		*102	376*	·			Page 2
Item ID: Revision ID: Item Name:	D2947 Clamp			Accept	*N900040	100*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	5/27/13 : 5/27/13	Start Qty: 60.00 Req'd Qty: 60.00		30* 30*	Cust Item ID: Customer:				
Approvals:	Proces QC:	s Plan:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 120 *120* QC Quality Control		Operation Description QC8- Inspect parts - seco		Set Up/ Run Hours	Tool ID Tool #	Plan Acce Code Qty	Qty		Reject Insp. Number Stamp
130 *120* Brake NC Brake NC		Bend as per dwg Small Fab Mem o		0.00		(δ	0		(369
150 *150* QC Quality Control		QC5- Inspect part comple Memo	eteness to step on	W/O 0.00 0.00 0.00 37	11	100			

												DQA:	Dat	e:	
NCR: Y	'es	/ No				WORK ORDER NON-C		NFOR	MANCE / UP	DATE		•		-	
												QA Closed:	Dat	e:	
Work Orde	· -					DISPOSITION				AGAINST I)E	PARTMENT,	PROCESS		
WOIK OIGE	·' -					Rework			Skid-tube	Crosstube	\neg	1	Water Jet	\neg	Engineering
Part N	lo.					Scrap			Machining	Small Fab	\dashv	Pro	d. Eng. Coor.	┪	Quality
	_					Use-as-is			noforming	Finishing		4	e/Packaging	┨	Other
NCR N	lo					Work Order Update			Large Fab	Composite			Supplier		
															
Root	Ī				· ·	ption of work order update	l .	nitial		tion		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	늬	QC Inspector
Doc/Data															
Equip/Tooling		·													
Operator					·						1				
Material											l				
Setup														Ì	
Other	П														
Process										•.					
Supplier							l						-		
Training															
Unapproved															
						F	AUL	T CATE	GORY						
Landi	ng G	ear				General		_		_		_	_		
		Bending				Bend		Grain				Ovalized	[Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardwa	ire	[Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete			Part Incorred	et [Weld
		Crushed/	Crimped			Burrs		Instruct	tions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination	Г	Mainte	enance			Part Moved	_		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Work	Order	ID :	10	23	76
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Page 3

May-28-13 8:48:04 AM

Item	ID:	
Revis	sion	ID:

D2947

Clamp Item Name:

Start Date: Required Date: 5/27/13

5/27/13

QC:

Req'd Qty: 60.00

Start Qty: 60.00

60

60

Cust Item ID:

N900040100

Date:

Tool # Plan

Code

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Date: _____ **Tooling:**

SPC (Y/N):

Accept

Set Up/

Run Hours

Date:

Run

Setup Start

Start

Stop

Reject

Qty

Insp.

Stamp

Sequence ID/ Work Center ID

160

Description Identify as per dwg & Stock Location:_

Operation

0.00

160

Packaging Packaging

Memo

50486 A

0.00

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Accept

Qty

Reject

Number

Quality Control

											DQA:	Date	e:
NCR: Y	res /	No				WORK ORDER NON-	COf	NFORM	MANCE / UPDATE		QA Closed:	Date	e:
Work Orde	ar.				·	DISPOSITION			AGA	INST DE	PARTMENT	/PROCESS	·
Part N	No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Cross Machining Small noforming Finis Large Fab Compo	Fab hing	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUI	LT CATE	GORY				
Landi	ng Gea					General	_	1 .			1	г	-
	Ce Cra Cra	acks ushed/0 ffs	ot Conce	ntric to	O/S	Bend BOM/Route Broken/Damaged Burrs Contamination		Instruct Mainte	ion Incomplete tions Incomplete/Unclear enance		Ovalized Over/Under Part Incorre Part Lost/M Part Moved	ct issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
1	He	at Trea	it		ļ	Countersink	1	Mislabe	eled	- 1	Positioned \	wrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID:

102376

Parent Item:

D2947

Parent Item Name:

Clamp

Start Date: 5/27/13

Required Date: 5/27/13

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP: A00.01.14New issueEC

IPP Rev:B No longer made in house 07-06-11 JLM

IPP REV:C 11.08.08. MADE IN

	HOUSE DD VER	F :EC											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	446.0842	0.062	3,915792	7		MB-7-10

Location	Loc Qty	Loc Code	
MAT020	446.0841688		
122245	0.1713688		
123136	140.8		
124428	23.61		
124572	25.5028		184573
125599	256		•

											DQA:	Da	ite:	
NCR: Y	'es	/ No				WORK ORDER NON-	COI	NFORM	AANCE / UPDATE	Ē				
											QA Closed:	Da	ite:	
Work Orde	ů.					DISPOSITION			A	GAINST DE	PARTMENT,	/PROCESS		-
Work Orde	:1.		<u>-</u>			Rework	1		Skid-tube Cro	osstube	1	Water Jet		Engineering
Part N	lo.					Scrap	1	•	⊢	nall Fab	Pro	d. Eng. Coor.	-	Quality
	٠٠.					Use-as-is	† †		ŬЩ	inishing	ł	re/Packaging	\vdash	Other
NCR N	lo.					Work Order Update	1	1	~ —	nposite		Supplier	-	
								_						
Root					Descr	iption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cł	nief Eng	Description	1	Date	Verificatio	n	QC Inspector
Doc/Data				ļ			1.							
Equip/Tooling													ļ	
Operator											1			-
Material												 		
Setup														
Other	Ш													
Process	Щ													
Supplier							1							
Training														
Unapproved				<u> </u>			<u> </u>							
<u> </u>		<u> </u>					AUI	LT CATE	GORY					
Landi		I			_	General	_	1		_	1		$\overline{}$	l
	\vdash	Bending			Ļ	Bend	_	Grain			Ovalized		\vdash	Pressure/Forced
	\vdash	Centre N	ot Conce	ntric to	O/S	BOM/Route	\vdash	Hardwa		<u> </u>	Over/Under		\vdash	Temperature/Cure
	—	Cracks			<u> </u>	Broken/Damaged	\vdash	4 '	on Incomplete	<u> </u>	Part Incorre		\vdash	Weld
•	<u> </u>	Crushed/	Crimped		\vdash	Burrs	\vdash	- 4	ions Incomplete/Unclea	r L	Part Lost/M	issing		Wrong Stock Pulled
	l	Cuffs			1	Contamination		Mainte	enance	1	Part Moved			

Mislabeled

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Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	102376
Description: Clamp	Part Number:	D2947
Inspection Dwg: D2947 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	0.258"	_		V	Jamos
0.40	+/-0.030	0,399"	_		V	JAMO
9.312	+/-0.010	9.312"	_		V	Produtos
0.75	+/-0.030	0.759"	_		V	racosoa
0.063	+/-0.010	0056	•		Y	
						·
		,				

			04		
Measured by:	Jm	Audited by:	276	Preliminary Approval:	
Date:	13-07-10	Date:	パフリ	Date:	

Rev	Date	Change		Revised	Abv.	Approved
A	12.01.31	New Issue		KJ 9	 \ 	AAA
			<u> </u>	7	Y) —	T WC

